

Date: Tuesday, 13/01/2009 4:07:31 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT GUIDE PLATE
 Job Number : 44735
 Estimate Number : 13364
 P.O. Number : Part Number : D35897
 This Issue : 13/01/2009 S.O. No. : Drawing Number : D3589 REV B PRELIM
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : B PRELIM
 Previous Run : 40372 Material :
 Written By : Due Date : 15/01/2009 Qty: 1 Um: Each
 Checked & Approved By : ME 09-1-13
 Comment : Est Rev:A 08-06-05 new issue DD verified by:ec

Additional Product

PRELIMINARY ISSUE

Job Number:



609.01.15 per EN40920P

Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.0650 sf(s)/Unit Total : 0.0650 sf(s)
 304/316 .063 Sheet
 batch: 109057 1B 9-1-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3589
 Dwg Rev: PRE
 Prog Rev: Lum

1B 9-1-15

①

2-Deburr if necessary 1B 9-1-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
1B 9-1-15

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK
1B 9-1-15

ENGINEERING APPROVAL

1B 9-1-15

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1- Bend as per Dwg D3589

SB 09/01/15

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/01/2009 4:07:31 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT GUIDE PLATE

Job Number: 44735

Part Number: D35897

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

09.01.15

①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/01/16 ①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.14 AUTH 1

RELEASED 1 DATE 09.02.17

MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

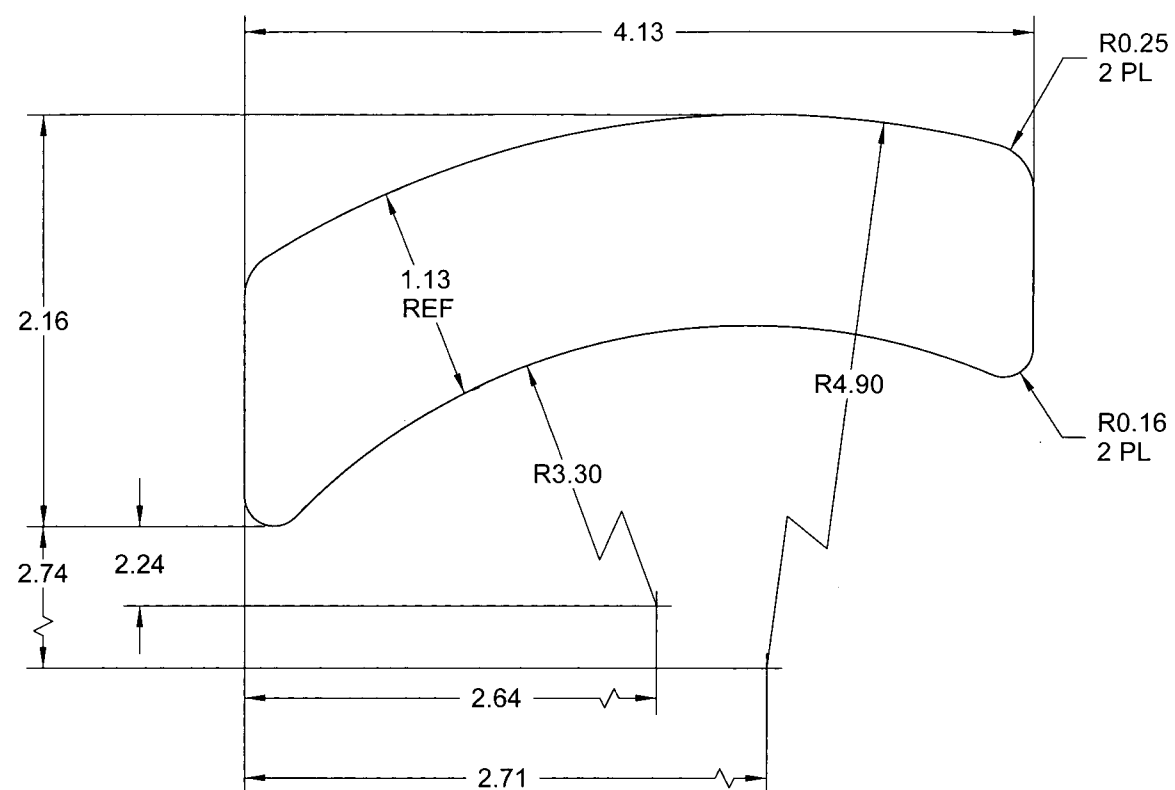
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

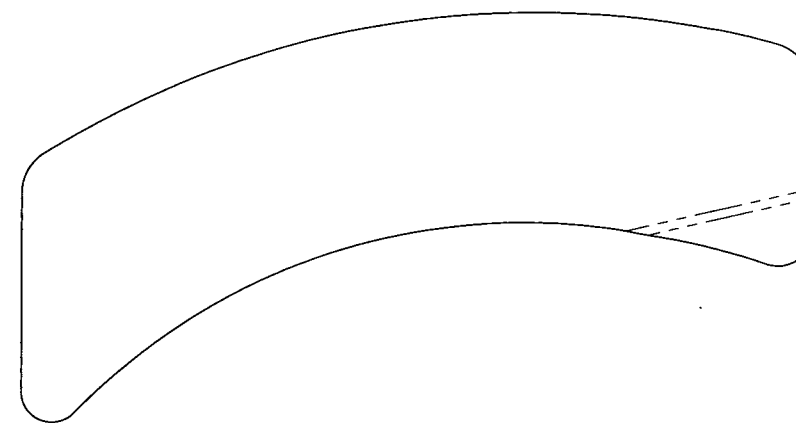
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D

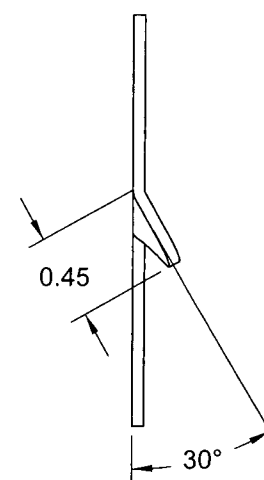
D



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F



44735

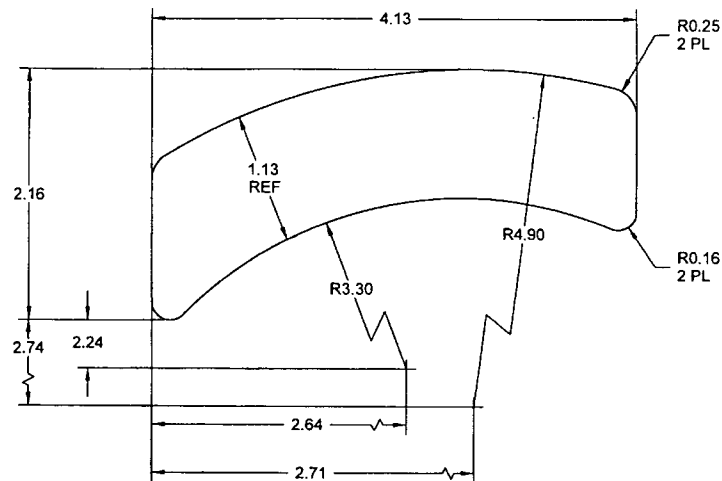
PRELIMINARY ISSUE

09.01.17
Per Rev #09.5028

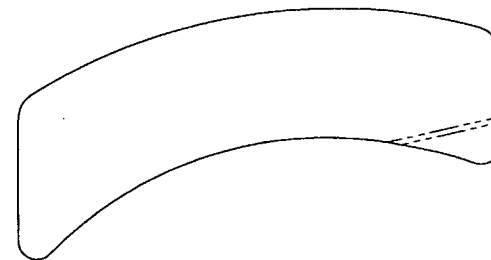
D3589-7/-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

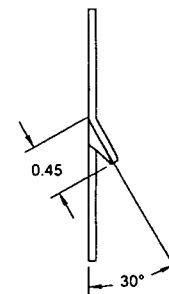
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**



44735

RELEASED
09/24/05 MB

D3589-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 5 OF 8
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